

Tuesday, 3/20/2007 2:36:14 PM
Kim Johnston

Process Sheet

SPR

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 31390	
Estimate Number : 10036	
P.O. Number : <i>NA</i>	Part Number : D6101013
This Issue : 3/20/2007 S.O. No. : <i>NA</i>	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25357	Material : <i>NA</i>
Written By : <i>[Signature]</i>	Due Date : 6/1/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>50</i> Um: <i>16</i> Each
Comment : Est. A: 01.05.04 New Issue EC	

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *3385*

C207/03/22

- a) Description: Aluminum billet
- b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000)
- c) Tolerance on all dimensions are +0.030"/-0.000"
- d) Grain direction along 10.100" length
- e) Material: 7075-T7351 (QQ-A-250/12)
- f) Material certification required

(50)

2.0 D6101013P Saddle billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 501.0000 Each(s)
Saddle billet

mk 07/08/28

16

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

C 7/1/27 (16)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

mk 07/08/28

16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/08/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 31390

Part Number: D6101013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

*mk 07/08/28**16*

6.0

QC21

FINAL INSPECTION/W/O RELEASE

*(16)*

Comment: FINAL INSPECTION/W/O RELEASE

07/08/28

Job Completion

*11 07-08-28*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

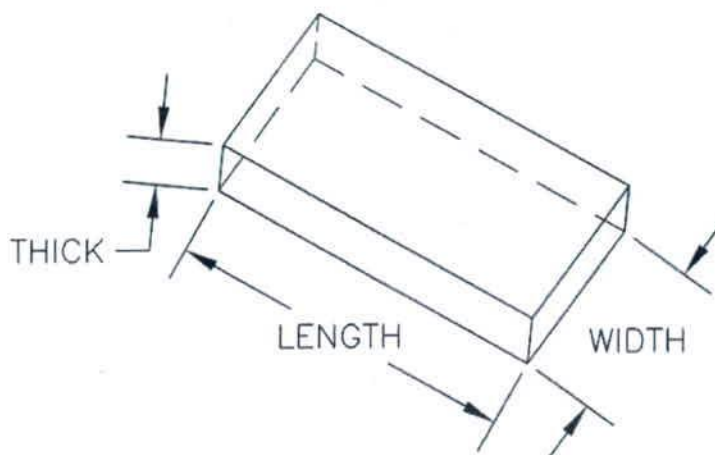
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 [Signature]



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

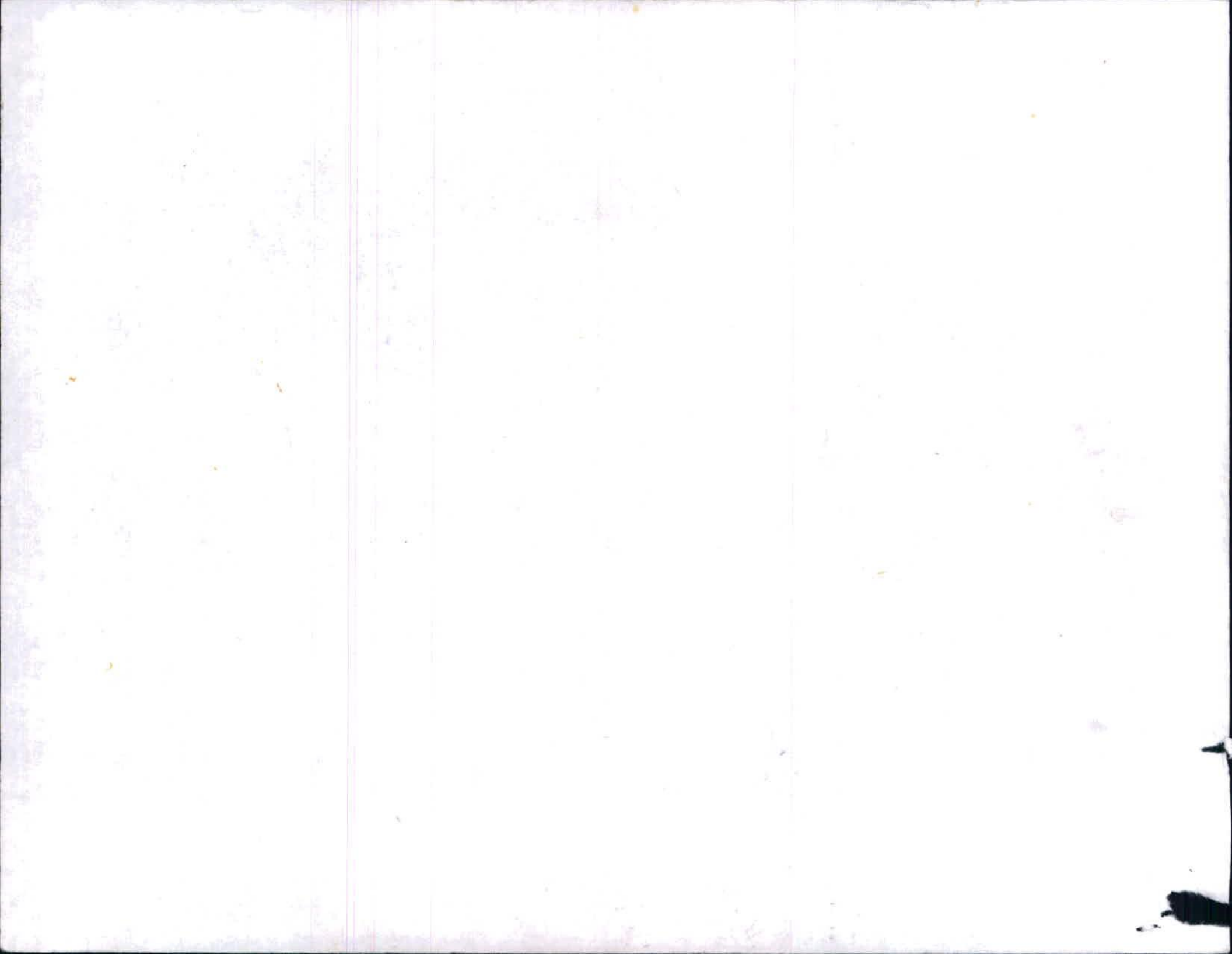
ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31390

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115-22-'07 08:23 FROM-

A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

T-913 P001/028 F-231

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4097183

HOLD TO:
AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-84287		WORK PACKAGE:		CUSTOMER PART NUMBER: 6879 A97075-80		SHIP RUN/LOAD ID: 100975/8		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1049113	LINE ITEM: 1	SHIP DATE: 16-MAY-2007	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 1784 LB	QUANTITY: 1 PCS EST.	B/L NUMBER: 2012858	GAUGE: 2.5000 IN		WIDTH: 48.500 IN	LENGTH: 144.500 IN			

Certified Specifications

AMS 4078/RevF
ASTM B 209/Rev06
BSS 7055/RevA
DPS 4.713/RevN/AmdAF
GSS16100/RevG

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevQ
EAC MS1011/RevD
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GAMPS 915/Rev
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 381369A8 Cast 972 Drop 75 Ingot 4

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	68.4 : 68.6 (472 : 473)	56.2 : 56.9 (387 : 392)	10.5 : 10.9

Conductivity %IACS :	42.1 Min	42.4 Max
(MS/M) :	24.4 Min	24.6 Max

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.12	0.22	1.53	0.01	2.54	0.19	5.65	0.02	0.01	0.01	TOT 0.03

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS CORP.

DATE RCVD 5/22/07

IAC 6879

APPROVED BY AW-2pas

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

T-913 P000028 F-231

CERTIFIED TEST REPORT

Serial Number
4097183

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A.
AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH
IS SOLID ON HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE.
TEST REPORTS ARE ON FILE SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER
ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE
PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POWNOR, LABORATORIES SUPERVISOR

Bill Pownor

